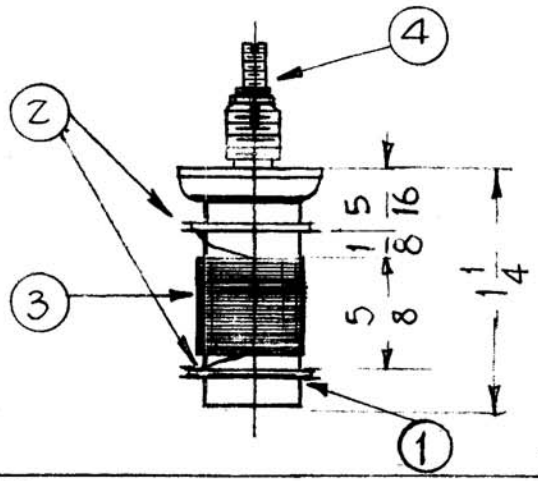
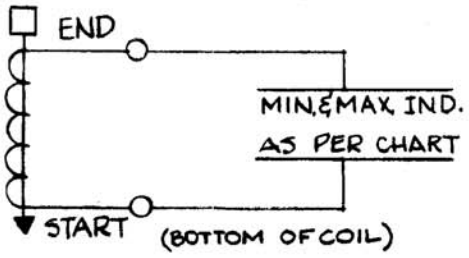
REQ. PER UNIT	USED ON MODEL	ASS'Y. NO.	DATE	A-1910	A
1	CLL-1		6-2-60		

PROCEDURE

1~ SECURE TERMINALS (ITEM 2) TO COIL FORM WITH INSULEX (ITEM 5).
2~ CLOSE WIND A SINGLE LAYER OF 53 TURNS OF ITEM 3, ON COIL FORM.
3~ STAKE WIRE ENDS TO COIL FORM WITH ITEM 4.
4~ SOLDER LEADS TO TERMINALS.
5~ BAKE FOR 1/2 HR. AT 210° F.
6~ PAINT COIL WITH INSULEX (ITEM 5).
7~ BAKE FOR 1/2 HR. AT 210°F.
8~ TEST UNIT AS PER CHART AND SCHEMATIC WITH CORE. MIN. MAX. INDUCTANCE ACCOMPLISHED BY ADJUSTING TUNING SLUG.

(USE BOONTON Q METER MODEL 160A or EQUIV.)





MAX. IND. - must be less than 55 uh
MIN. IND - must be more than 25 uh
Q at 2.5 mc must be more than 75
OPERATING FREQ. - 510 Kc.

REQ.	ITEM	PART NO.	DESCRIPTION	SYMBOL
X	6	BS-100	SOLDER SOFT	
X	5	GL-104-2	INSULEX, U85	
1	4	CI-109-21	COIL SLUG	
X	3	WI-107-15	WIRE	
2	2	TE-146-2	TERMINAL RING	
1	1	CF-129	COIL FORM	

ISSUE	ITEM	CHANGED FROM	DATE	CH. NO.	DRAFTS	CHECKER	ENG. APP.
A		ADD QTY'S & ITI CALLOUT	11-15-66	17261	RME		

TOLERANCES

DEC. DIM. ±
FRAC. DIM. ±
ANGULAR DIM. ±

SCALE:

MAXIMUM ALLOWABLE TOLERANCES HAVE BEEN DETERMINED AND ANY DEVIATIONS WILL BE CAUSE FOR REJECTION. REMOVE ALL BURRS AND SHARP EDGES

STOCK SIZE

MATERIAL

TYPE & TEMPER | HEAT TREAT. SPEC.

FINISH & SPEC. NO.

THE TECHNICAL MATERIEL CORP.
MAMARONECK, NEW YORK

CL-235 ASSEMBLY

DRAWN	CHECKED	FINAL APPROVAL
D.J.M.	J.H.R.	
ELEC. DES. APP	MECH. DES. APP	A-1910 A
P.A.		

FORM 108-A